

Duplicate ship 14/may

**Work Order ID 82650**

**\*82650\***

Page 1

April-30-12 7:39:37 AM

Item ID: D4417-011

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/04/12 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2690

B2

D4417

B

100

Pick Kit

0.00

**\*100\***

Packaging

Memo

0.00

Packaging

120

0.00

**\*120\***

HandFinish

Memo

0.00

Hand Finishing

1- ASSEMBLE AS PER DWG  
2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240  
CABLE AND CRIMP CBL-460 AS PER DWG D2690

2  $\phi$

BL12-5-10

**Work Order ID 82650**

April-30-12 7:39:37 AM

**\*82650\***

Page 2

Item ID: D4417-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/04/12 Start Qty: 2.00 **\*2\***

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00 **\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

210

Identify as per dwg &amp; Stock Location: \_\_\_\_\_ 0.00

**\*210\***

Packaging

Memo

PPP 82648

0.00

Packaging

220

QC21- Final Inspection - Work Order Release 0.00

**\*220\***

QC

Memo

0.00

Quality Control

①

12.05.10

12/15/11 (2)

12/15/14

12-05-11

# Picklist Print

April-30-12 7:39:36 AM

Page 1

Work Order ID: 82650

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/04/12

Required Date: 4/30/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC IPP REV:B 11.08.17 PER  
REVB. DD VERF:JLM IPP REV:C 11.10.25 replace D2690-6 for CBL-460 & CBL-  
1240 for assembling purpose DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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CBL-1240 Cable		Purchased	No			120	f	494.8672	0.708	1.416			
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Location	Loc Qty	Loc Code
GA	494.867189	
113565	3.911789	
119021	477.922	
119690	13.0334	

17.5" X 2

BL 12-58.

CBL-460 Loop Sleeve		Purchased	No			120	Each	1,000.0000	2	4			
------------------------	--	-----------	----	--	--	-----	------	------------	---	---	--	--	--

Location	Loc Qty	Loc Code
GA	1000	
121574	1000	

4.

BL 12-58.

D4417-041 Step Assembly		Manufactured	No			120	Each	0.0000	1	2			
----------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4418-1 Step Lug		Manufactured	No			120	Each	2.0000	2	4			
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Location	Loc Qty	Loc Code
st139h	2	
73193	2	

2.  
2

BL 12-58.

D2570 Bushing		Manufactured	No			120	Each	606.0000	4	8			
------------------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST011	606	
72960	41	
78586	9	
79493	12	
81956	144	
81957	400	

8

BL 12-58.

# Picklist Print

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Page 2

Work Order ID: 82650

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/04/12

Required Date: 4/30/12

Start Qty: 2.00

Required Qty: 2.00

AN4C16A Purchased No 120 Each 28.0000 2 4  
BOLT

Location	Loc Qty	Loc Code
ST358	28	
117441 ✓	18	
121259	10	

4.

BL 12-5-8.

AN4C36A Purchased No 120 Each 44.0000 2 4  
Bolt

Location	Loc Qty	Loc Code
ST360	44	
118518 ✓	44	

4.

BL 12-5-8.

MS17984-C415 Purchased No 120 Each 6.0000 2 4  
Pin, Quick Release

Location	Loc Qty	Loc Code
ST315	6	
118352 ✓	2	
118840 ✓	4	

2.

BL 12-5-8.

MS21043-4 Purchased No 120 Each 1,336.0000 4 8  
Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1296	
119546	213	
120308	83	
121162 ✓	1000	

8

BL 12-5-8.

D4428-1 Manufactured No 120 Each 8.0000 2 4  
Bushing

Location	Loc Qty	Loc Code
ST139F	8	
72555	2	
73195 ✓	6	

4

BL 12-5-8.

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 82650

Parent Item: D4417-011

Parent Item Name: Q.R. Step Assembly (206L/407)

Start Date: 4/04/12

Required Date: 4/30/12

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

120

Each

4,542.0000

8

16

Washer

bk 125-8.

## Location

## Loc Qty

## Loc Code

ST297

1578

117291 ✓

578

119124

1000

ST298

2964

121255

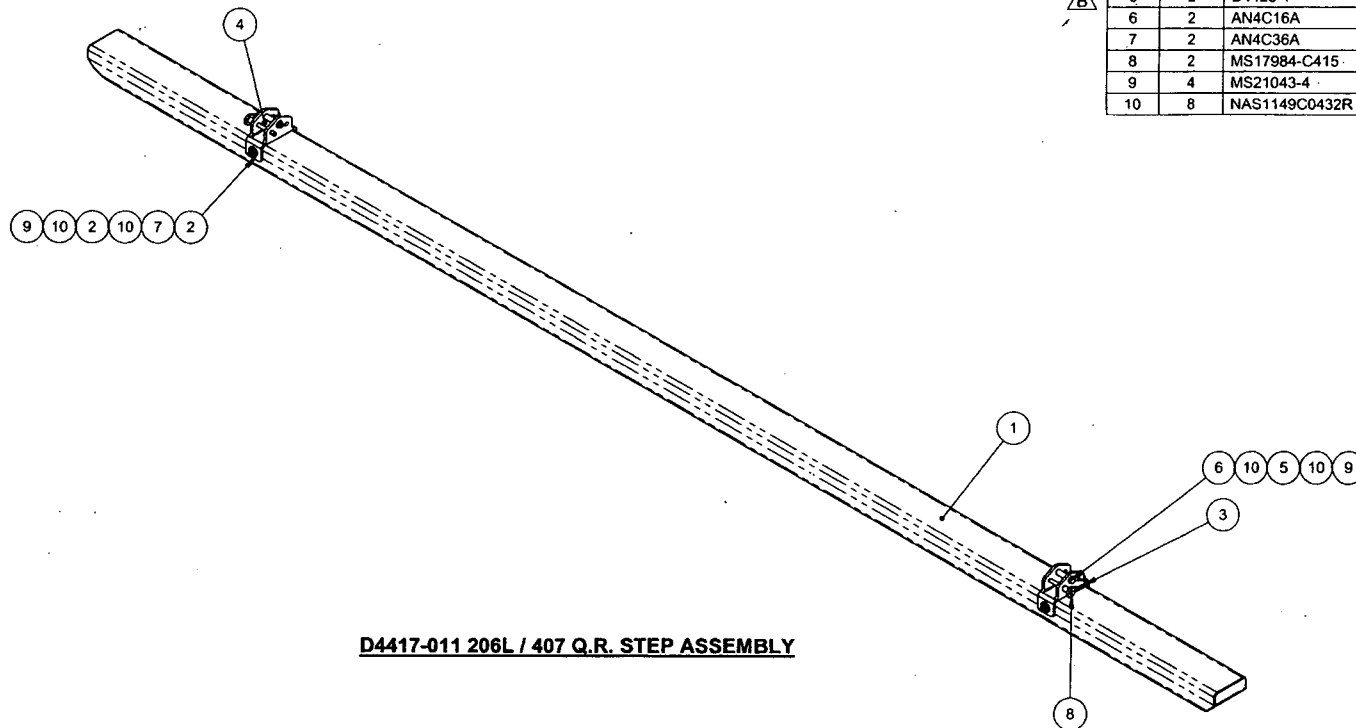
2964

16  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

April-30-12 7:39:37 AM

Shop Packet Print

Page 3



ITEM	QTY -011	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

**D4417-011 206L / 407 Q.R. STEP ASSEMBLY**

**RELEASED**  
2011-08-02

B	REPLACED NAS43DD4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.28		

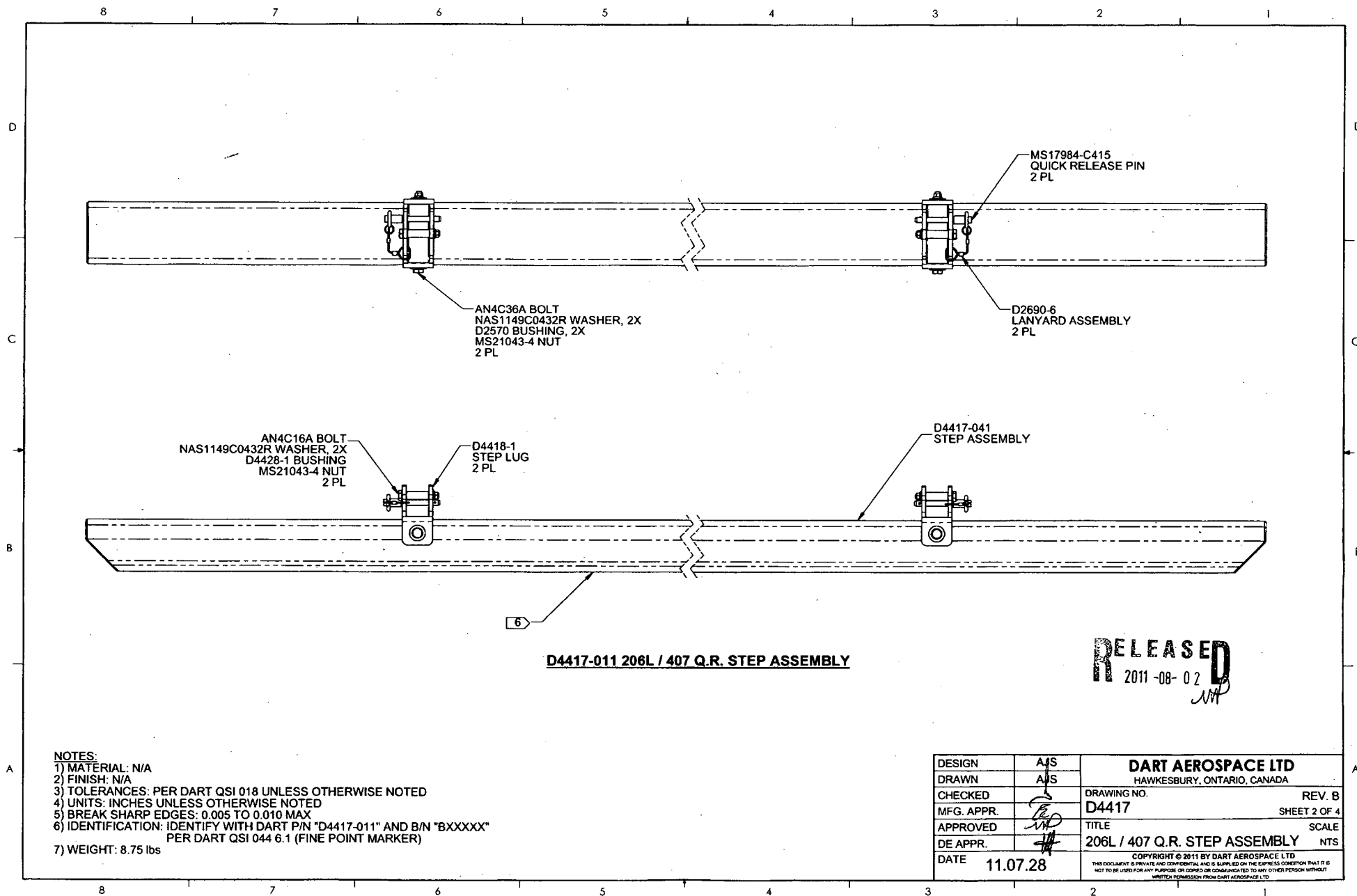
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4417** REV. B  
SHEET 1 OF 4

TITLE **206L / 407 Q.R. STEP ASSEMBLY** SCALE NTS

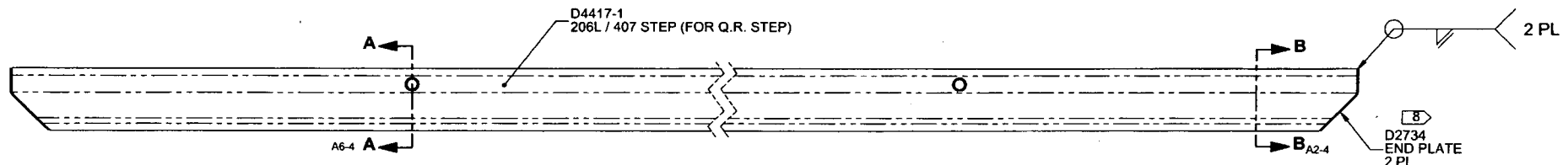
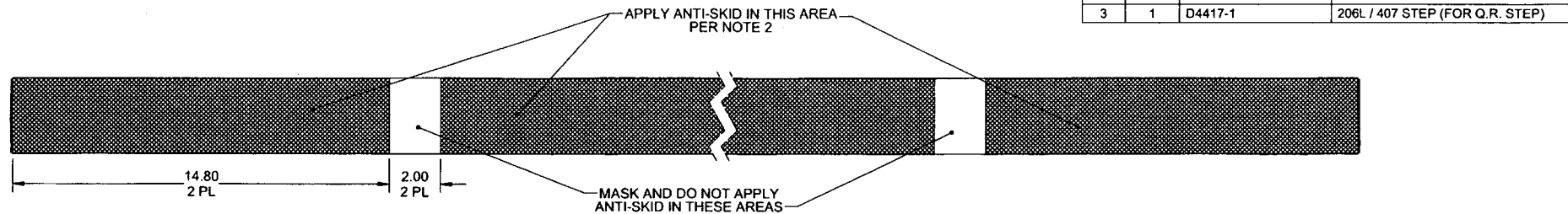
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Langyard  
couper 8"  $\frac{3}{4}$   
6" CENTRE DU LOOP.  
2.20" chaque bout

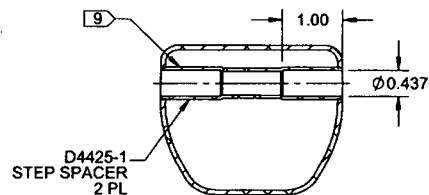




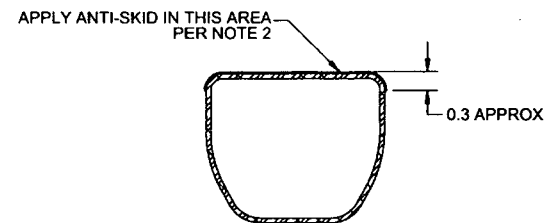
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)



**D4417-041 STEP ASSEMBLY**



**SECTION A-A C7-4**  
SCALE 2X



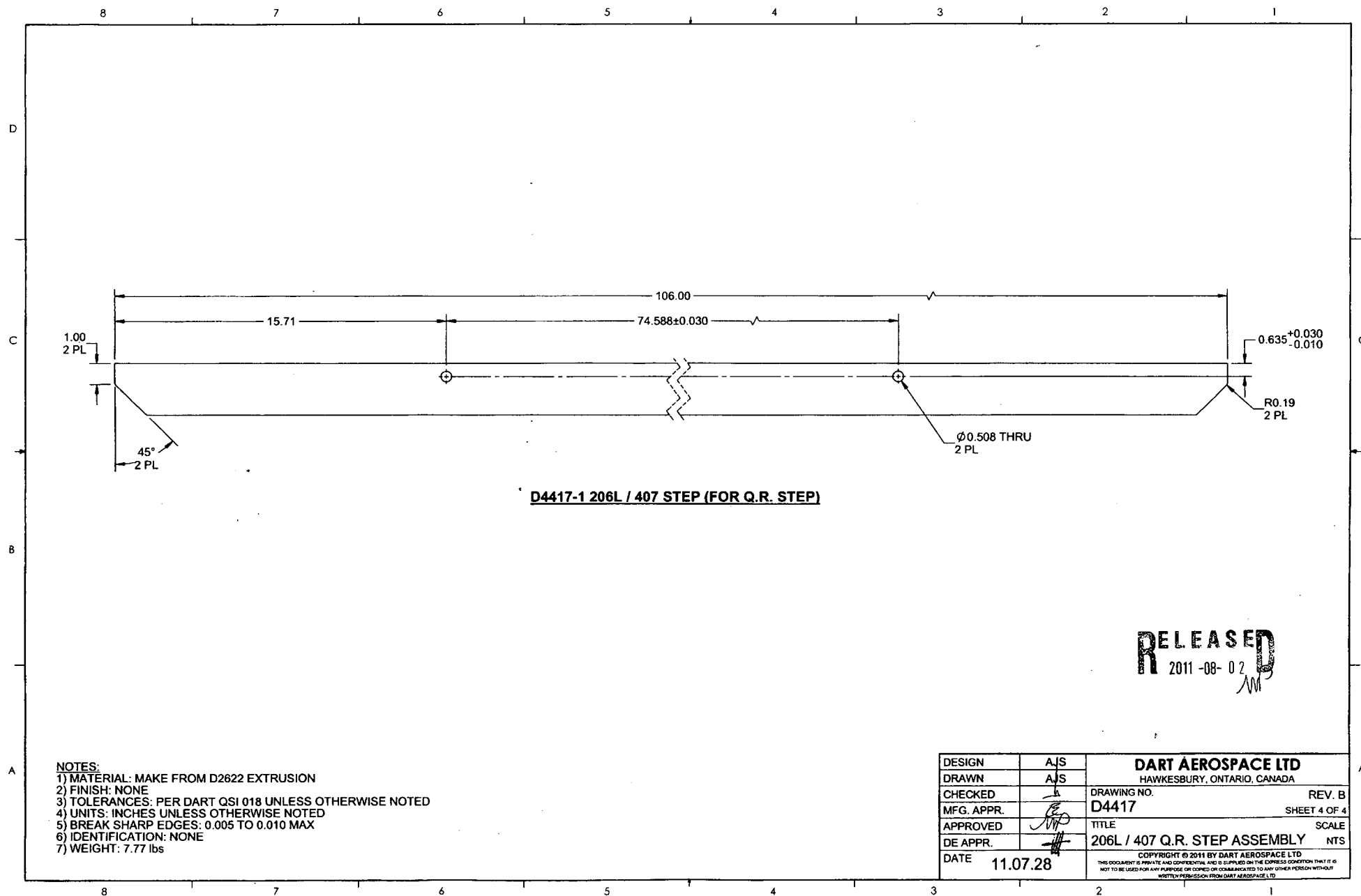
**SECTION B-B C2-4**  
SCALE 2X

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002





DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. B
MFG. APPR.	E	<b>D4417</b>	SHEET 3 OF 4
APPROVED	M	TITLE	SCALE
DE APPR.	M	<b>206L / 407 Q.R. STEP ASSEMBLY</b>	NTS
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**RELEASED**  
2011-08-02  
MD



- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 7.77 lbs

**RELEASED**  
2011-08-02

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4417	SHEET 4 OF 4
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